Work Orde June 4, 2010 11:		466	2 2									Page 1
Item ID: Revision ID: Item Name:	D4122-3 Floor Protecto		ARY • IIII	Solvens					Setup	Start Stop		1
Required Date: 6 Reference:		Start Qty: 3.0 Req'd Qty: 3.0		III) t	Cust Item II Customer:	D;						
	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ite:			Run	Start Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Réje Qty		Reject Number	Insp. Stamp
Draw Nbr D4122	Rev	vision Nbr							1.	45,		
	. ·	FLOW WATER JE	Γ	0.00			. :	—Bu	<i>9-16</i>	<u> </u>	.	
Waterjet FLOW CNC Waterjet	t	Dwg R Prog R		0.00		* * * * * * * * * * * * * * * * * * *						3
110 OC			off machine FAI/FAIB	0.00				<u>k</u> s	,10-11	0 - Da	<u>ن</u>	
Quality Control		Memo		0.00								4
120		QC8- Inspect parts		0.00								
QC Quality Control		Memo	To un release Rees. B \(\int_{10.10-2}	0.00				70 m	elens,	eel R	w.B.	howa
			210-10-2	O								

W/O:			WC	ORK ORDER CHANGES					•
DATE	STEP	PROC	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				3 2	وننو	-			
Part No		PAR #:							
	. R	esolution:		-				Date:	
NCR:		Wo	ORK ORDE	R NON-CONFORMANC	CE (NC	R)	-		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign Dat			Approval Chief Eng	Approval QC Inspector
								·	
		,							
	1								

Work Order ID 59466

Page 2

June 4, 2010 11:52:01 AM

Required Date: 6/14/10

Item ID:

D4122-3

Accept

Setup Start

Revision ID:

Item Name:

Floor Protector, Aft

Start Date:

6/10/10

Start Qty: 3.00

Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop



Sequence ID/ **Work Center ID**

130

Small Fab

Small Fab

Operation Description

QC:

Set Up/ **Run Hours**

Date:_____

0.00

0.00

Deburr if necessary.

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty

Insp. Number

Stamp

140



Quality Control

QC5- Inspect part completeness to step on W/O

150

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo PPP 63>81

C/W/10/213/

Small Fab

Memo

Memo

0.00

0.00

W/O:			V	VORK ORDER	CHANGES					· ·
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
i										
			,							
	<u> </u>									
Part No	:	PAR #:	Fault Ca	tegory:		ICR: Yes	No DQA :		_ Date: _	
		Resolution:								
NCR:		1	WORK OR	DER NON-COI	NFORMANO	CE (NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action			Verifica	tion	Approval	Approval
		Section A	Chief Eng	Action De	Eng	Sign & Date	Section	ı C	Chief Eng	QC Inspector
					-				, ,	
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										,
										,

Work Order ID 59466

June 4, 2010 11:52:02 AM



Page 3

Item ID:

D4122-3

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Floor Protector, Aft

Required Date: 6/14/10

6/10/10

Start Qty: 3.00 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Operation

Description

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/

Work Center ID

Memo

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan

Date:

Code Qty

Reject Accept Qty

Reject Number

Insp. Stamp

0.00

W10.10,21

POSITIVE RECALL

AUTH

DATE WOOD

ON TO THE TOTAL TO THE

Quality Control

W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE					Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
			<u>į. </u>										
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Ye	s No	DQA:	Date:					
	Re	esolution:	Disposition: QA: N/C C					Date: _	*				
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NO	CR)							
DATE	STEP	Description of NC	Corrective Action Section B				Verification	n Approval	Approval				
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	on Sign & Date		Section C	Chief Eng	QC Inspector				

									Pickers and Pickers				
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Picklist Print

June 4, 2010 11:52:00 AM

Work Order ID: 59466

Parent Item:

D4122-3

Parent Item Name: Floor Protector, Aft

Comments:

IPP Rev:A 10.06.04 new issue DD verf:JLM



Start Date: 6/10/10

Required Date: 6/14/10

Page 1

Start Qty: 3.00

Required Qty: 3.00

(B10-10-20)

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No		100	sf	1,762.106	8.803	27.79895	40	`	

GE PLASTICS LEXAN SHEET

Locatio	<u>n</u>	Loc Qty	Loc Code	
MAT		1762.1068		
	111710	64		
	112585	165.783		
	114032	1532.3238		
	115261			115 261

W/O:			W	ORK ORDER CHAN	GES	······			
DATE	STEP	PR		Ву	Date Qt	y Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							-		
Part No	•	PAR #:	Fault Cat	egory:	NCF	R: Yes N	lo DQA:	Date:	
Resolution: Disposition:				on:	QA:	N/C Clo	sed:	Date: _	
NCR:			WORK ORI	DER NON-CONFORM	MANCE	(NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action Se Action Description	ection B	Sign &	Verificatio		Approvai
		Section A	Chief Eng	Chief Eng		Date	Section C	Chief Eng	QC Inspector
					·				
								:	
	,								

DART AEROSPACE LTD	Work Order:	59.466
Description: Floor PROTECTOR ATT	Part Number:	D4199-3
Inspection Dwg: 04(2)-3 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST X First Article Prototype

	X	First Artic	le _	Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
\$ 3.00	100 510. >	G00,5	×		V ROZ	
1.75	4 30	1,745	8		V ,	
PG. C	4 .030	7.295	SX		V	
16.24	4.030	16.24	4	,	T BOI	
36.62	4 .030	36.62	×		1	
\$7.37	7L 330	57.37	A	<u> </u>	7	
77.74	4 .030	77.74	800		T	
93.98	4 .030	93,48	×	<u> </u>	7	
4.00	71 030	4.00	A		7	
4.90	4- 30	4,90	D		7	
8.65	4- 30	8.65	8		17	
9.76	4/ 030	9.26	7	<u> </u>	T	
13.50	7/030	13,50	7		T	
,125	الم الم	131	\ <u>\</u>		7	
				<u> </u>		
						,
	·					<u> </u>
						9%
				/		

Measured by: |B | Audited by: | Prototype Approval: N/A | To Rev R

_				Revised by	Approved
	Rev	Date	Change	KJ/JLM	
Ī	Α		New Issue	TOOLEGE	

13.50 4.90 4.00 R1.50 4 PL →- 2.29

D4122-3 FLOOR PROTECTOR, AFT

PER ECN 10-633

REV. B

D

С

В

NOTES.
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,
TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
2) FINICH, NOME

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: DART P/N "D4122-3" PER DART QSI 044 6.1
7) WEIGHT: 0.76 DS

CHECKED MFG. APPR APPROVED DE APPR. DATE 10.10.13

DESIGN

DRAWN

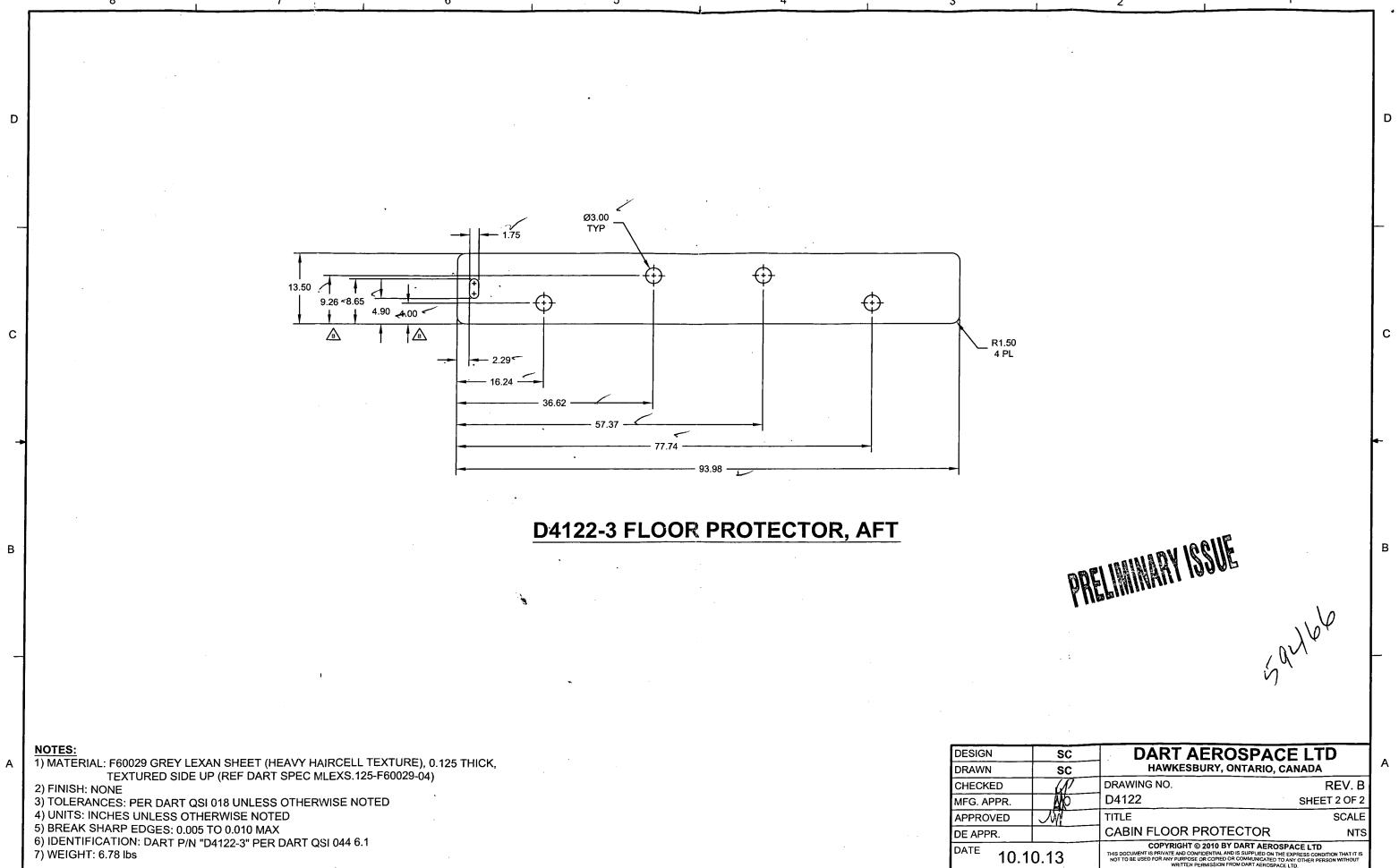
D4122 SHEET 2 OF 2 TITLE SCALE CABIN FLOOR PROTECTOR

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

sc

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